

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claims 1-36 (cancelled).

Claim 37 (new): A screw plug of metallic material comprising a cylindrical shank (36), having an external thread (22), a top plate (12) in which a blind hole (28) of polygonal cross section is provided centrally as a receiving member for a tool, the shank (36) having the form of a tube stub (14) provided with the external thread (22) and from an end face (16) of the shank there extends a further blind hole (18) which is coaxial with the blind hole (28) in the top plate (12).

Claim 38 (new): A screw plug comprising a bevelled portion (24) inclined axis-wards from a top plate (12) as a transition to the shank (36), wherein a tube-ward foot contour (25) of the bevelled portion constitutes an inner starting line for an external thread (22) projecting radially beyond the foot contour.

Claim 39 (new): A screw plug according to claim 38, wherein the bevelled portion (24), widening towards the top, of the screw plug (10) forms an angle ( $w$ ), in longitudinal section, with the longitudinal axis (A) of the screw, which angle measures about  $30^\circ$ .

Claim 40 (new) : A screw plug according to claim 38, wherein a diameter (g) of the foot contour (25) of the bevelled portion (24) of 19.5 mm.

Claim 41 (new) : A screw plug according to claim 37, wherein a deepest point (20) of the further blind hole (18) in the tube stub (14) exhibits a cross-section inclined from a wall surface (19) thereof to a longitudinal axis (A) of the screw.

Claim 42 (new) : A screw plug according to claim 41, wherein a depth (c) of the wall surface (19) of between 7.8 mm and 8 mm.

Claim 43 (new) : A screw plug according to claim 37, wherein a diameter (e) of the further blind hole (18) of about 14 mm and an external diameter (f) of the external thread (22) of about 21 mm.

Claim 44 (new) : A screw plug according to claim 37, wherein associated with the tube edge (16) is at least one bevelled edge (15 or 17) inclined away therefrom towards the top plate.

Claim 45 (new) : A screw plug according to claim 44, wherein a bevelled edge (15, 17) inclined away from the tube edge towards the top is associated in each case on both sides with the tube edge (16).

Claim 46 (new) : A screw plug according to claim 45, wherein the outer bevelled edge (17) develops into the external thread (22).

Claim 47 (new) : A method of producing a screw plug according to claim 37, comprises producing a blank (34) with a cylindrical tube stub (36) formed on and adjoining a top plate (12) whose internal diameter ( $e_1$ ) and external diameter ( $f_1$ ) are smaller than the corresponding diameters (e, f) intended for the screw plug (10), and in that the tube stub (36) of the blank is expanded by exerting pressure on the inner wall surface (19<sub>a</sub>) of the blind hole (18<sub>a</sub>) thereof.

Claim 48 (new) : A method according to claim 47, wherein a portion (52) of a plunger (50) of larger cross-section than the internal diameter ( $e_1$ ) of the blind hole (18<sub>a</sub>) in the tube stub (36) of the blank (34) is introduced into said blind hole as a mandrel-type tool and the tube stub is expanded radially thereby.

Claim 49 (new) : A method according to claim 47, wherein the outer surface (38) of the tube stub (36) is forced out radially beyond the foot contour (25) of a bevelled portion (24) adjoining the top plate (12) and inclined cross-sectionally axis-wards.

Claim 50 (new) : A method according to claim 47, wherein an external thread (22) is formed in an outer surface (38) of the expanded tube stub (36).

Claim 51 (new) : A method according to claim 50, wherein the external thread (22) is formed in the area of the tube stub (36) determined in the axis-ward direction by the foot contour (25) of the bevelled portion (24).

Claim 52 (new) : A method according to claim 50, wherein the external thread (22) is formed in the outer surface (38) of the tube stub (36) by the thread rolling method.

Claim 53 (new) : A method according to claim 50, wherein the outer surface (38) of the tube stub (36) is pressed against a die surrounding it.

Claim 54 (new) : A blank for producing a screw plug (10) according to claim 37, comprising a top plate (12) of the blank (34) is adjoined by a cylindrical tube stub (36) with an external diameter ( $f_1$ ) and a diameter ( $e_1$ ) of the blind hole ( $18_a$ ) whose dimensions are smaller than those of the external diameter ( $f$ ) and hole diameter ( $e$ ) of the screw plug (10).

Claim 55 (new) : A blank according to claim 54, wherein the external diameter ( $f_1$ ) of the tube stub (36) on the blank (34) is smaller than the foot diameter ( $g$ ) of the bevelled portion (24) on the screw plug (10).

Claim 56 (new) : A blank according to claim 55, wherein the bevelled portion (24) of the blank (34) forms an angle ( $w$ ) with the longitudinal axis (A) of the blank which preferably measures around  $30^\circ$ .

Claim 57 (new) : A blank according to claim 55, wherein a diameter ( $e_1$ ) of the blind hole ( $18_a$ ) of about 12 mm and an external diameter ( $f_1$ ) of the tube stub (36) of about 19 mm.

Claim 58 (new) : A blank according to claim 54, wherein a bevelled edge ( $15_a, 17_a$ ) inclined away from a tube edge is

associated in each case on both sides with the tube edge (16<sub>a</sub>) of the tube stub (36).

Claim 59 (new) : A blank according to claim 58, wherein the outer bevelled edge (17<sub>a</sub>) of the tube stub (36) develops into the cylindrical outer tube surface (38).

Claim 60 (new) : A tool for producing a screw plug (10) according to claim 37, wherein a plunger (50) is fixed at one end in a housing (42) as a mandrel-type tool and the free end thereof is associated with a carrying or holding head (68) arranged movably relative thereto and having a receptacle for a blank (34), wherein the axis (A) thereof extends in the central axis (M) of the tool (40) or the plunger.

Claim 61 (new) : A tool according to claim 60, wherein a stationary base plate (44) is associated with the bush-like housing (42) at the end remote from the carrying or holding head (68), which base plate forms an abutment for the plunger (50) seated thereon.

Claim 62 (new) : A tool according to claim 61, wherein a free end of the plunger (50) partially surrounded by a plunger tube (54) engages in a central bore (70) in the carrying or holding head (68), wherein a pressure head (52) of the plunger projects axially beyond the edge (56) of the mouth of the plunger tube.

Claim 63 (new) : A tool according to claim 62, wherein the plunger tube (54) is seated at its other end, preferably with a flange foot (57), on a stationary upright sleeve (48) of

the tool (40), which forms a bearing surface for the plunger (50) passing through the upright sleeve.

Claim 64 (new) : A tool according to claim 63, wherein a disk-like central pressure base (46) of the base plate (44) as an abutment for the plunger (50) and the upright bush (48).

Claim 65 (new) : A tool according to claim 64, wherein the carrying or holding head (68) is seated on a slide bush (60), which is associated coaxially with the plunger (50) and the upright bush (48).

Claim 66 (new) : A tool according to claim 65, wherein a diameter ( $q_1$ ) of the pressure base (46) approximately matches the diameter seated thereon of the slide bush (60).

Claim 67 (new) : A tool according to claim 66, wherein on a foot portion (64<sub>t</sub>) associated with the pressure base (46), the slide bush (60) comprises a head portion (64) wider radially than said foot portion.

Claim 68 (new) : A tool according to claim 67, wherein the slide bush (60), with the holding head (68), is surrounded supportingly by a guide chuck (80) and arranged to be axially movable therewith relative to the housing (42).

Claim 69 (new) : A tool according to claim 68, wherein an energy storing device (78) is arranged between the base plate (44) and the guide chuck (80).

Claim 70 (new) : A tool according to claim 69, wherein the energy storing device takes the form of a profile element (78) of resilient material.

Claim 71 (new) : A tool according to claim 70, wherein the energy storing device or profile element (78) is positioned in the manner of a ring around the pressure base (46) of the base plate (44).

Claim 72 (new) : A tool according to claim 7, wherein the blank (34) seated in the carrying or holding head (68) is arranged so as to be forceable, on axial movement thereof, onto the pressure head (52) of the plunger (50), wherein the diameter thereof is larger than the diameter ( $e_1$ ) of the blind hole (18<sub>a</sub>) in the blank.